

## Sikaflex® -252J Structural Adhesive

### Product Data Sheet :

Chemical base	One-component polyurethane
Colour	White/Black
Density (uncured)	1.16 – 1.22 kg/l depending on colour
Stability (non-sag properties)	Very good
Cure mechanism	Moisture-curing
Tack-free time <sup>1)</sup>	40 min., approx.
Rate of cure <sup>1)</sup>	3.5 mm/24 hrs., approx. (see diagram)
Shrinkage	-6%, approx.
Shore A hardness	55, approx.
Tensile strength	3N/mm <sup>2</sup> , approx. (31 kgf/cm <sup>2</sup> , approx.)
Elongation at break	> 300%
Tear strength	9 N/mm, approx. (9 kgf/cm, approx.)
Tensile shear strength for a 4 mm applied thickness	2.5 N/mm <sup>2</sup> , approx. (26 kgf/cm <sup>2</sup> , approx.)
Volume resistivity	10 <sup>6</sup> Ω cm, approx.
Glass transition temperature	-45°C, approx.
Service temperature (continuous) <sup>2)</sup>	-40°C to +90°C
short term (up to 36 hrs.) <sup>2)</sup>	+120°C
Shelf life (stored below 25°C)	6 months

<sup>1)</sup> = at 23°C and 50% relative humidity

<sup>2)</sup> = after curing

#### Description:

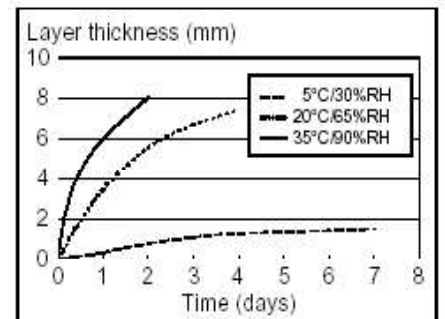
Sikaflex®-252J is a non-sag one-part polyurethane adhesive of stiff, pastelike consistency that cures on exposure to atmospheric moisture to form a durable elastomer. Sikaflex®-252J is manufactured in accordance with the ISO 9001/14001 quality assurance system.

#### Product benefits:

- One-part formulation
- Elastic
- Can be overpainted
- Good gap-filling capabilities
- Capable of withstanding high dynamic stresses
- Vibration-damping
- Non-corrosive
- Electrically non-conductive
- Bonds well to a wide variety of substrates

#### Cure mechanism:

Sikaflex®-252J cures by reaction with atmospheric moisture. At low temperatures the water content of the air is generally lower and the curing reaction proceeds slower (see diagram).



### Areas of application:

Sikaflex®-252J is suitable for structural joints that will be subjected to dynamic stresses. Suitable substrate materials are timber, metals, particularly aluminium (including anodized components), sheet steel (including phosphated, chromated and zinc-plated components), metal primers and paint coatings (two-part systems), ceramic materials and plastics. Seek manufacturer's advice before using on plastics that are prone to stress cracking. Do not apply at temperatures below 10 °C or above 35 °C. The optimum temperature for substrate and adhesive is between 15°C and 25°C. For cartridge application we recommend the use of a compressed air piston type cartridge gun. For advice on selecting and setting up a suitable pump system, as well as on the techniques of pumpoperated application, please contact our System Engineering Department.

This product is suitable for professional experienced users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

### Chemical resistance:

Sikaflex®-252J is resistant to fresh water, seawater, limewater, sewage effluent, dilute acids and caustic solutions; temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to organic acids, alcohol, concentrated mineral acids and caustic solutions or solvents.

The above information is offered for general guidance only. Advice on specific applications will be given on request.

### Method of application:

*General information.* The joints should be designed and dimensioned in accordance with Sika's standard recommendations for elastic adhesives.

*Surface preparation:* Surfaces must be clean, dry and free from all traces of grease, oil, wax and dust. As a rule the bond faces must be prepared in accordance with the instructions given in the current Sika Primer Chart.

*Application:* For cartridges: pierce the cartridge membrane and peel back completely. For unipacs: place in the application gun and snip off the closure clip.

Cut off the tip of the nozzle. To ensure uniform thickness of adhesive when compressed, we recommend to apply the adhesive in the form of a triangular bead (see illustration).

Do not apply at temperatures below 10 °C or above 35 °C. The optimum temperature for substrate and adhesive is between 15°C and 25°C. For cartridge application we recommend the use of a compressed air piston type cartridge gun.

For advice on selecting and setting up a suitable pump system, as well as on the techniques of pumpoperated application, please contact our System Engineering Department.

*Tooling and finishing:* Tooling and finishing must be carried out within the tack-free time of the adhesive. We recommend the use of Sika® Tooling Agent N. Other finishing agents or lubricants must be tested for suitability/compatibility.

*Overpainting:* Sikaflex®-252J can be overpainted when tack-free. The paint must be tested for compatibility by carrying out preliminary trials.

Baked enamels should not be applied to Sikaflex®-252J until the adhesive has attained full cure. It should be understood that the hardness and film thickness of the paint may impair the elasticity of the adhesive and lead to cracking of the paint film.

### Removal:

Uncured Sikaflex®-252J may be removed from tools and equipment with Sika® Remover-208. Once cured, the material can only be removed mechanically. Hands and exposed skin should be washed immediately using a suitable industrial hand cleanser and water. Do not use solvents!

### Further information:

Copies of the following publications are available on request:

- Sika Primer Chart
- Safety Data Sheet
- Calculation Basics

### Packaging information:

Unipack	600 ml
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### Value Bases

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

### Health and Safety Information

For information and advice on the safe handling, storage and disposal of chemical products, users should refer to the current Safety Data Sheet containing physical, ecological, toxicological and other safety-related data.

### Legal Notes

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users should always refer to the most recent issue of the Product Data Sheet for the product concerned, copies of which will be supplied on request.



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